

Date: Monday, 18/06/2007 11:48:30 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: STRIP PAINT
Job Number	: 32918		
Estimate Number	: 10804		
P.O. Number	: <i>N/A</i>	Part Number	: D206642411
This Issue	: 18/06/2007 S.O. No. : <i>N/A</i>	Drawing Number	: STRIP PARTS
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: 18/06/2007 Type : MACHINED PARTS	Drawing Revision	: <i>N/A</i>
Previous Run	: 00015	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 25/06/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

✓ 44 X D2651-1 PLUG B ~~28389~~
 2 X D2891-1 SUPPORT B ~~28077~~ 1X B 19647 1X
 2 X D2892-1 SUPPORT B ~~28389~~
 1 X D2933-1 SADDLE B ~~31115~~
 1 X D2938-1 SADDLE B ~~29347~~
 1 X D2939-1 SADDLE B ~~28922~~
 1 X D2932-2 SADDLE B ~~31250~~
 1 X D2938-2 SADDLE B ~~29348~~

07/06/18

2.0	D26511	Plug
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Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)
 Plug

B 31788 M.L 07/06/19

(44X)

3.0	D28911	Support 2.25 dia
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Support 2.25 dia

B 19647 1X - B 28077 1X - M.L 07/06/19

(2X)

4.0	D28921	Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Support

B 28389 -

M.L 07/06/19

(2X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/06/2007 11:48:31 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: STRIP PAINT

Job Number: 32918

Part Number: D206642411

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D29331	206 Saddle Left
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Left *B31115*

6.0	D29381	206 Saddle Left side
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Left side *B29347*

7.0	D29391	206 Saddle Left side
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Left side *B28922*

8.0	D29322	206 Saddle Right side
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Right side *B31250*

9.0	D29382	206 Saddle Right side
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
206 Saddle Right side *B29348*

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

STRIP PARTS AND RE-ALODINE

M-L

07/06/19

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

RESTOCK USING ORIGINAL B/N

*strip part
Delft Blue*

Debusse

PO 4034

07-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/06/2007 11:48:31 AM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: STRIP PAINT

Job Number: 32918

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



QC14

2070622



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



14 Pkg - restock
using same B/N's

20706/25

15 QC 21

Final Inspection

(1)

20706126

2070626

Dait Aerospace
1270 Aberdeen St
Hawkesbury ont
K6A-1K7

N° DE COMMANDE - ORDER NO.	DÉP. - DEPT.	DATE
VENDU À - SOLD TO	EXPÉDIÉ À - SHIP TO	
ADRESSE - ADDRESS	ADRESSE - ADDRESS	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
2		D2646 B32375	* as per OSI 005 *	
✓ 4		D2659 B32376		
✓ 8		D2731-7 B30995		
✓ 2		D2968-043 B32311		
✓ 8		D3394-043 B30998		
✓ 1		D2939-2 B32385	✓ 1 D2938-1 b29347	
			✓ 1 D2933-1 B31115	
✓ 1		D2932-1 B32377	✓ 1 D2938-2 B29348	
			✓ 1 D2939-1 B28922	
✓ 1		D2933-2 B32380	✓ 1 D2932-2 B31250	
1		D2724-041 B32391A -		
1		D2724-042 B32392A -		
1		D206-642-441 B31754A		
1		D206-642-441 B32393A -		
1		D206-667-103 B32138		
1		D206-667-203 B30433		

114321

SIGNATURE

N° LIC. - LIC. NO.

TPS/GST

TVP/PST

TOTAL

4.2 Prime, Paint

 **REFERENCE ONLY**

4.2.1 Prime

4.2.1.1 Prepare all surfaces to be primed using Dupont 4105S Wash' n' Wipe Degreaser. Be sure not to leave any residue on the parts by passing a good quality tack rag over surface.

4.2.1.2 Prepare 2-part epoxy primer in accordance with manufacturer's instructions.

4.2.1.2.1 Acceptable primers for aluminum are:

- a) Any MIL-P-23377 primer
- b) Any MIL-P-85582 primer
- c) Tempo 4500-P-23 primer (consists of 4500-P-23 base and 4500-C-23 catalyst)

4.2.1.2.2 Acceptable primers for composite coatings are:

- a) Tempo 4500-P-40 primer (consists of 4500-P-40 base and 4500-C-40 catalyst)
- b) Dupont 2K urethane Primer: - 1144SC
Catalyst - 1125S
Reducer- 1175S

4.2.1.3 Mix primer / paint as per manufacturer's instructions and allow to activate.

4.2.1.4 Priming crosstubes: Pour primer into tube as necessary. Submerge; saturate the sponge with primer and drag through the tube back and forth until complete coverage is achieved. Empty the tube of remaining primer. When applying the primer to the parts surface, use light even coats until the part is homogenous in colour as per the manufacturer's instructions.

4.2.1.5 Preferred procedure is to prime crosstubes with Tempo 4500-P-23. Allow the Tempo 4500-P-23 to dry from 4 hours minimum to 6 hours maximum before applying the topcoat. This is to be done under normal conditions of 77°F and 50% relative humidity as per manufacturer's instructions. If the Tempo 4500-P-23 primer dry time exceeds 7 hours before applying the topcoat, let the primer cure for 16-18 hours and sand lightly using a maximum 320 grit sanding paper.

4.2.1.6 Allow primer to dry before painting.



REFERENCE ONLY

4.2.2 Paint

Prime per QSI 005 section 4.2. **DO NOT** perform section 4.2.2.1 or 4.2.2.2 if painting crosstubes primed per section 4.2.1.5.

4.2.2.1 Mask part per Dwg. A light sanding with scotchbrite or 400 grit sandpaper may be necessary for proper paint adhesion.

4.2.2.2 Prepare all surfaces to be painted using Dupont 4105S Wash' n' Wipe Degreaser. Be sure not to leave any residue on the parts by passing a good quality tack rag over surface.

4.2.2.3 Prepare paint in accordance with manufacturer's instructions.

Acceptable paints are:

- a) Any MIL-C-85285 polyurethane paint
- b) Any MIL-C-83286 polyurethane paint
- c) AWL GRIP G8001 white base +
AWL GRIP G3010 converter +
AWL GRIP T0003 reducer
- d) Dupont Imron Polyurethane Enamel Base white (555U) + Dupont Imron Polyurethane Enamel Activator 192S [mix 3:1].

Note: Use **only** Imron polyurethane enamel paint when top coating with Tempo 4500-P-23 primer on the crosstubes.

4.2.2.4 Apply to part surfaces with spray gun until parts are homogeneous in color. Ensure regulator is set correctly for paint mixture type.

4.2.2.5 Allow paint flash time, as per manufacturer's instructions, before applying the next coat.

4.2.2.6 Apply 2nd coat of paint as required.

4.2.2.7 Allow paint to harden to the point that the finish will not be disturbed in further operations (approximately 16-18 hours)

4.3 Powder Coat

4.3.1 Prepare steel parts for powder coating by washing them with Dupont 4105S Wash n' Wipe Degreaser or R1900 Thinner to remove any grease, oils and markers on the part before pressure washing. Parts are to be heat pressure washed at 180° F, and rinsed using a wash hose with cool clean water. Dry the parts by pre-heating as per section 4.3.5 temperature chart.